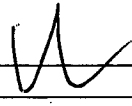
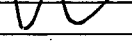


Date: Friday, 06/07/2007 1:36:25 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER DECKPLATE 350
Job Number	: 33262		
Estimate Number	: 10357		
P.O. Number	: NIA	Part Number	: D2344
This Issue	: 06/07/2007 S.O. No. : NIA	Drawing Number	: D2344 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NA Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 33262	Material	: NIA
Written By	: 	Due Date	: 10/07/2007 Qty: 4 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC Est Rev:E 07-07-04 Asper Rev F JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.7823 sf(s)/Unit Total: 3.1290 sf(s)
 Material: 2024-T3 QQ-A-250/5) .063
 Batch: M104921

SAD 07/07/29

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

Dwg ASR F
 Preg F

SAD 07/07/29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/02

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/08/02 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL/MED FAB

1-Deburr sharp edges a.m

07.08.07

2-Countersink holes per Dwg D2344

MF

07-08-10

Date: Friday, 06/07/2007 1:36:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 33262

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/14 (4X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/22 (4X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m/02316

FL 07/08/23 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/23 59 (4X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location:

EP 07/08/23 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24 (4)

Job Completion



U 07/08/24

Date: Friday, 6/29/2007 11:17:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER DECKPLATE 350
Job Number : 33262	
Estimate Number : 10357	
P.O. Number :	Part Number : D2344
This Issue : 6/29/2007 S.O. No. :	Drawing Number : D2344 UNDER REVIEW-
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E F
Previous Run : 31918	Material :
Written By :	Due Date : 7/10/2007 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.7823 sf(s)/Unit Total : 3.1290 sf(s)
 Material: 2024-T3 QQ-A-250/5) .063
 Batch _____

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/29/2007 11:17:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 33262

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: E F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005					
6.223	+/-0.010	6.222	✓		Vern	
5.598	+/-0.010	5.598	✓		Vern	
4.869	+/-0.010	4.868	✓		Vern	
3.889	+/-0.010	3.885	✓		Vern	
3.096	+/-0.010	3.101	✓		Vern	
2.891	+/-0.010	2.899	✓		Vern	
16.973	+/-0.010	16.963	✓		M-T/Vern	
0.966	+/-0.005					
0.450	+/-0.010	0.457	✓		Vern	
4.423	+/-0.010	4.423	✓		Vern	
4.723	+/-0.010	4.722	✓		Vern	
1.202	+/-0.010	1.204	✓		Vern	
5.869	+/-0.010	5.870	✓		Vern	
4.654	+/-0.010	4.650	✓		Vern	
Ø0.656	+0.005/-0.000	Ø0.657	✓		Vern	
1.888	+/-0.010	1.891	✓		Vern	
2.285	+/-0.010	2.290	✓		Vern	
2.683	+/-0.010	2.685	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.173	✓		Vern	
0.750	+/-0.005					
3.491	+/-0.010	3.494	✓		Vern	
Ø0.191	+0.005/-0.000	Ø0.192	✓		Vern	
0.796	+/-0.005					
3.123	+/-0.010	3.127	✓		Vern	
1.597	+/-0.010					
1.975	+/-0.010	1.980	✓		Vern	
Ø0.128		Ø0.128	✓		Vern	
Measured by:	SAM	Audited by:	EP	Prototype Approval:		N/A
Date:	07/08/02	Date:	07/08/02	Date:		N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	

